

75550

Tuesday, October 25, 2011 8:41:12 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/25/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/25/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: mt Date: 11-10-25 Tooling:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Draw Nbr	Revision Nbr
DSI 9579	A

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP DSI 9579-011 CHG001

CHG001

8/10/25

For MLJ 11-10-25

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

11/10/25 ~~S~~ (K)

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

Schultz

64

Work Order ID 75550***75550***

Page 2

Item ID: DSI 9579-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Composite Door Upgrade

Start Date: 10/25/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9579-011

Location:

PPP rev:

130

0.00

130

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/10/2011

11/10/2011

ME 11-10-2011

Picklist Print

Tuesday, October 25, 2011 8:41:12 AM

Page 1

Work Order ID: 75550

Parent Item: DSI 9579-011

Parent Item Name: Composite Door Upgrade

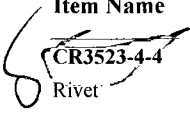
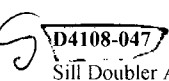

Start Date: 10/25/2011

Required Date: 10/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.10.25 as per dwg rev.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 CR3523-4-4 Rivet		Purchased	No			110	Each	26.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST314		26							
				115768		26							
 D4108-047 Sill Doubler Assembly		Manufactured	No			110	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST129		4							
				64489		4							
 D4108-11 Template		Manufactured	No			110	Each	9.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st128		9							
				64488		9							

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0

REF CANADIAN STC: SH10-44

REF FAA STC: SR02933NY

REF EASA STC: 10033253

REFERENCE ONLY

1.0 PURPOSE:

It has come to Dart's attention that a portion of the airframe on recent Bell 206L4 aircraft is made of composite. In such cases, installing the D4112-1 (ref. D206-802-032 Kit) per IIN-D206-802-3 might not be possible. To that effect, Dart has created DSI-9579-011 Upgrade Kit to facilitate installation of D206-802-032 Kits at Change 001. The parts list of D206-802-032 Kits at Change 002 and later is amended as follows:

2.0 PARTS LIST CHANGE:

5.2 D206-802-031/-032 Passenger Door Opener Kits (IIN-D206-802-3 Rev. A)
52.4.9 D206-802-031/-032 Passenger Door Opener Kits (ICA-D407-802 Rev. 0)

Qty -031	Qty -032	Part Number	Description
<input checked="" type="checkbox"/>	<input type="checkbox"/>	D206-802-031	PASSENGER DOOR OPENER KIT, LH
<input type="checkbox"/>	<input checked="" type="checkbox"/>	D206-802-032	PASSENGER DOOR OPENER KIT, RH

ADD:

	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
	4	CR3523-4-4	RIVET

3.0 DSI-9579-011 UPGRADE KIT PARTS LIST:

Qty -011	Part Number	Description
<input checked="" type="checkbox"/>	DSI-9579-011	UPGRADE KIT
1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.10.21

CERT. NO.: SH10-44

ISSUE NO.: 1

A	NEW ISSUE	MB	11.10.14
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9579	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		UPGRADE KIT	NTS
DATE	11.10.14	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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4.0 INSTALLATION CHANGE:

4.1 On metal airframe:

No change. Install D206-802-032 using D4112-1 per Section 3.3 of IIN-D206-802-3.

4.2 On composite airframe:

Install D206-802-032 by replacing D4112-1 Aft Sill Doubler with D4108-047 per instructions below and Figure 1 of this Service Instruction.

4.2.1 Perform Step 3.3.1 of IIN-D206-802-3.

4.2.2 Replace Steps 3.3.2 to 3.3.15 with the following:






- a) Using Figure 1 of this Service Instruction, locate D4108-11 Template on the edge of the door post closeout approximately 17.5" from the front of the seat. Match drill the Ø0.128" rivet holes (4 PL) on the door sill. Locate and drill thru template and door sill if the door sill is without existing holes.
- b) Transfer drill the Ø0.128" holes (4 PL) from D4108-11 Template to the D4108-047 Sill Bracket Assembly.
- c) Deburr all drilled holes and clean area.
- d) Remove and retain the Ball Stud and hardware from the D4108-047 Sill Bracket Assembly.
- e) Install D4108-047 Sill Bracket Assembly by applying a thin layer of Proseal 890 and wet installing the CR3523-4-4 Rivets (4 PL) as shown in Figure 1 of this Service Instruction.
- f) Remove excess Proseal, grind rivet stems flush and clean area of any debris.
- g) Re-install the Ball Stud and hardware removed at Step "d)" of this instruction.
- h) Re-position the carpet and interior trim panel. Trim/cut as required for the ball stud and to allow the D4108-047 Sill Bracket Assembly to protrude.
- i) Re-install the scuff plate.
- j) Install rod end of D3552-17 Door Prop onto the Ball Stud mounted on D4108-047 Sill Bracket Assembly.

4.2.3 Complete installation of D206-802-032 by following Steps 3.3.16 to 3.3.29 of Installation Instructions IIN-D206-802-3.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 11.10.21
CERT. NO.: SH10-44
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9579	SHEET 2 OF 3
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REFERENCE ONLY

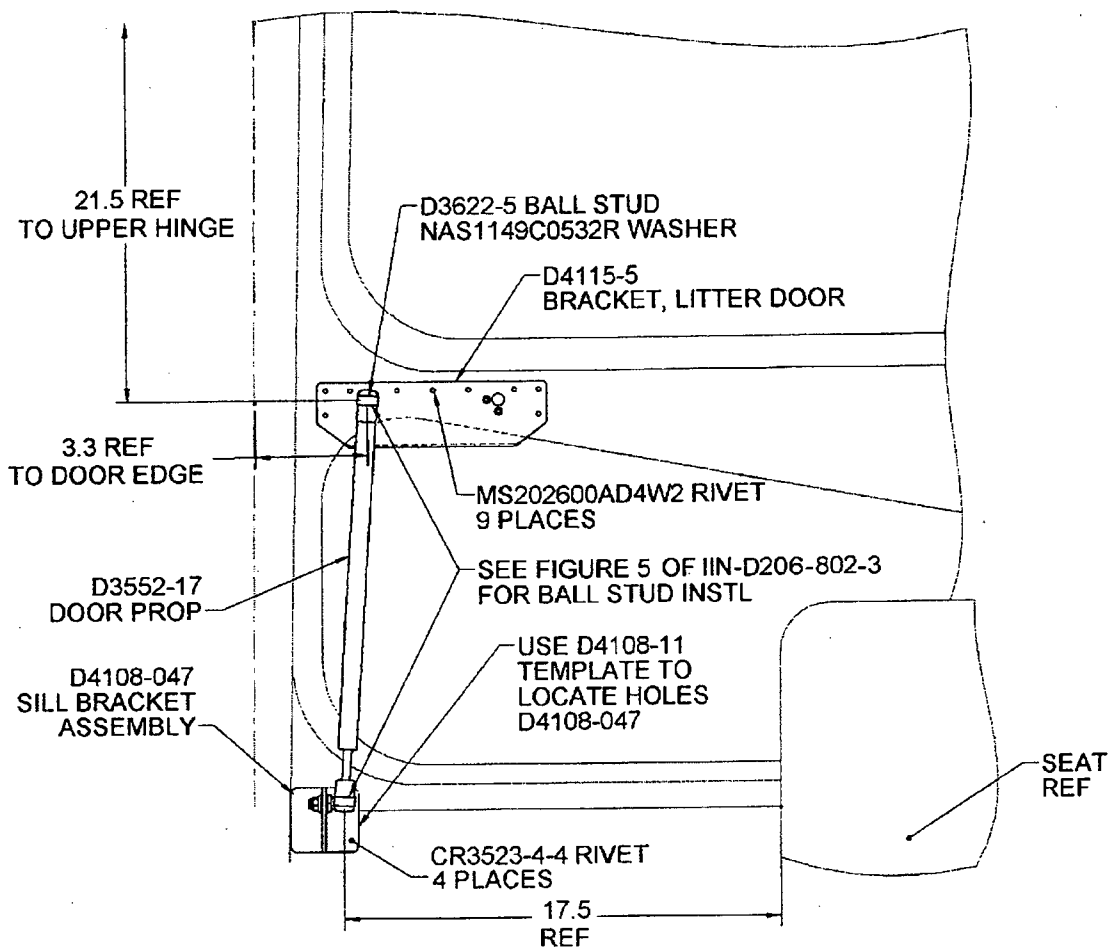


FIGURE 1: INSTALLATION OF D206-802-032 ON COMPOSITE AIRFRAME

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.10.21
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MFG. APPR.	N/A	DSI 9579	SHEET 3 OF 3
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